

Date: Thursday, 5/25/2006 3:37:35 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LATCH PLATE
 Job Number : 27252
 Estimate Number : 10511
 P.O. Number : N/A Part Number : D2621
 This Issue : 5/25/2006 S.O. No. : N/A Drawing Number : D2621 REV. B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : B
 Previous Run : 25903 Material : N/A
 Due Date : 6/20/2006 Qty: 40 Um: Each
 Written By : *SEE IN COMMENT BELOW*
 Checked & Approved By : *06.05.25*
 Comment : Est: C 02.02.28 Added inspection level 8 and level 5
 SM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S040 5052-H32 .040 Sheet



Comment: Qty.: 0.0656 sf(s)/Unit Total : 2.6250 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.040" thick

(M5052H32S040)

Batch: *M17835*

M 06.05.30

2.0

SHEAR

SHEAR



Comment: SHEAR

Cut blank: 4.000" x 2.130"

N/A

06.05.29

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio and Dwg D2621

2- Deburr

Identify as D2621

Water Jet

Dwg Rev B

Prog Rev B

H-M 06/05/31

M 06.05.30

(40)

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M 06.05.30

(40)

5.0

QC8

SECOND CHECK


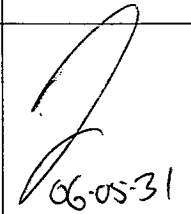




Comment: SECOND CHECK

Er 06/05/31

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/05/05	#3	one (1) Part scrap. MATH Delaminated when cutting out INSIDE Pattern on water St.		Scrap and destroy Part.	En 06/05/30	 06-05-31		 06-05-30

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/06/05

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH PLATE

Job Number: 27252

Part Number: D2621

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DL 06/05/01

(40)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

DL 06/05/01

(40)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AL 06/06/01

(40)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 8T53

AL 06/06/01

(40)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

AL 06/06/02

(40)

Job Completion



u 06/06/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

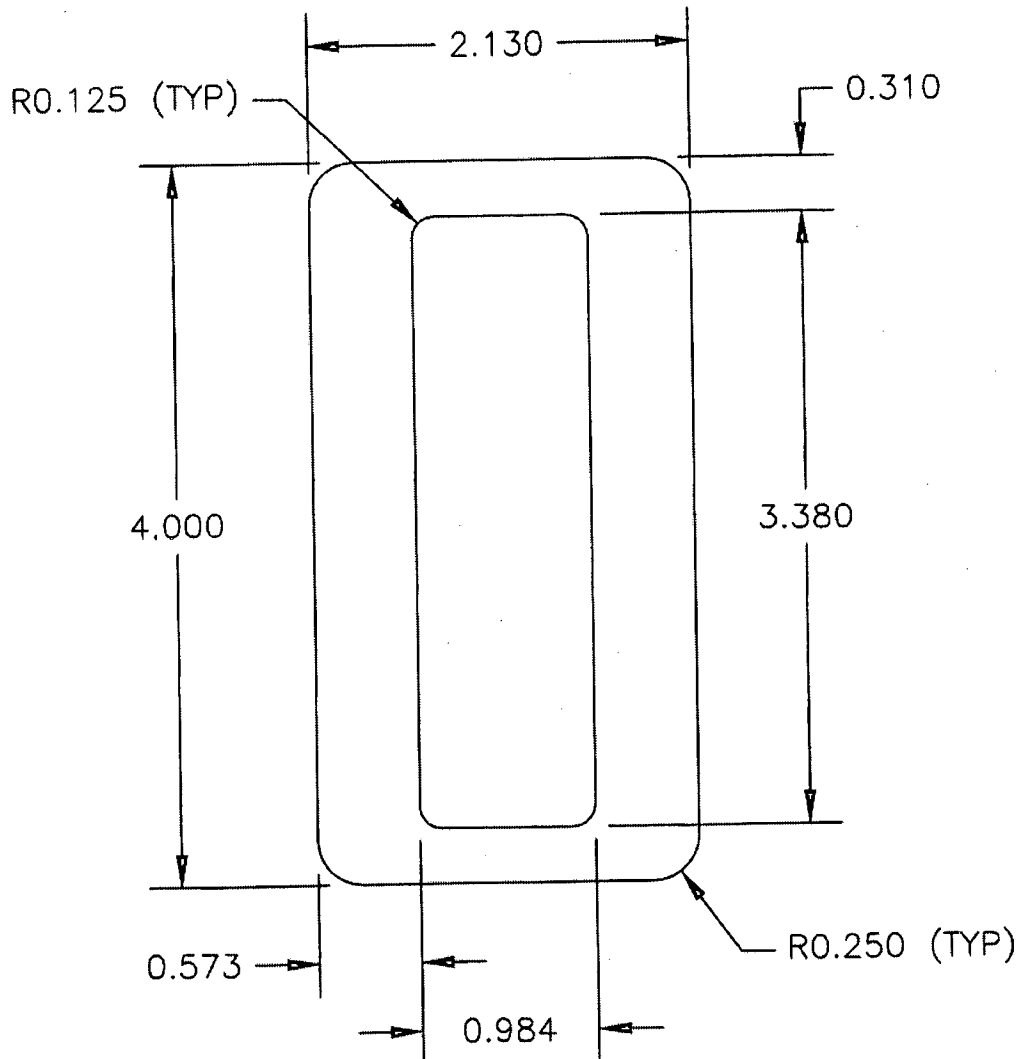
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN BW	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2621	REV. B SHEET 1 OF 1
DATE 00.06.01		TITLE LATCH PLATE	SCALE 1:1
A	96.08.15	NEW ISSUE	
B	00.06.01	ADDED FINISH; R0.125 WAS R0.118	

RELEASED
00.06.05 *[Signature]*



MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11) OR 2024-T3
(QQ-A-250/4) 0.040 THICK
FINISH: CHEMICAL CONVERSION COAT PER DART 005 4.1
POWDER COAT BLACK SANTEX (REF. 4.3.5.7) PER DART QSI 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY

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ENGINEERING

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 27252

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